# Work Order ID 108371

*October-16-13 2:38:43 PM*

*108371*



**Item ID:** D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

**Required Date:** 10/31/13 **Req'd Qty:** 1.00 *1* **Customer:**

**Reference:**

**Run Start** *NR1*

**Approvals:** **Process Plan:** MLS **Date:** 13-10-16 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | **Memo** | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile and create labels per PPP D350-604-041 CHG006 ~~CHG006~~ CHG005 | | | | | | | | |

JB POSITIVE RECALL

| Draw Nbr | Revision Nbr |
|---|---|
| D2273 | ~~H~~ H |
| D350-604-041 | D |

EFFECTIVE 3.10.16 AUTH

RELEASED GP DATE 14/4/7

DAS 14/1/8

6

9-89

(1)

PART NUMBER: D2273
REV LEVEL: -H
UN-CLASS
Product : 350 Rear Locker Extender
12/2/2013
Customer: Dart SN # 15914-2
PO # 21721
WO # 7389
Weight 6.34 Lbs
D2273

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

**Item ID:** D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
**Required Date:** 10/31/13 **Req'd Qty:** 1.00 *1* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 110 | PURCHASING | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Purchasing | | 0.00 | | | | | | | |
| Purchasing | **Memo**<br>Issue P/O: 21721<br>Description: D350-604-041 Rear locker extender.<br>Manufacture as per dwg D2273<br>Supplier: Carbon-by-Design<br>Certification of Conformity and process sheet from Carbon-by-Design is required.<br><br>***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.***<br><br>***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE*** | | | | | | | | |
| 120 | Receive & Inspect for Damage & Mat'l Certs | 0.00 | | | | | | | |
| *120* | Packaging | | | | | | | | |
| Packaging | | 0.00 | | | | | | | |
| Packaging | **Memo**<br>Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.<br><br>***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM*** | | | | | | | | |

CL 13/10/17 ①

13/12/04 ①

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

**Item ID:** D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
**Required Date:** 10/31/13 **Req'd Qty:** 1.00 *1* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *130* | | | | | | 1 | | | 13·12·04 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | Check hole locations to template. DT 8824 Check process sheet and audit. | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | | | | | | 1 | | | 13·12·04 |
| Small Fab | **Memo** | 0.00 | | | | | | | |
| Small Fab | 1- INSTALL DECALS AS PER DWG | | | | | | | | |
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | DAS 9 ~~9-89~~ |
| *150* | | | | | | 1 | | JAN 07 2014 | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6.0LB

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

**Item ID:** D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
**Required Date:** 10/31/13 **Req'd Qty:** 1.00 *1* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 155 | Pick Kit | 0.00 | | | | | | | |
| *155* | | | | | | 1 | | DAS 33 9-89 | 14-01-07 |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM*** | | | | | | | | DAS 9-89 |
| 158 | QC4- 100% Inspect kits for completeness | 0.00 | AS 9-89 | | | 1 | | | |
| *158* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | | 0.00 | | | | | | | |
| *160* | Packaging | | | | | 14/1/8 | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D350-604-041<br>Location: 698<br>PPP Rev: _____ | | | | | | | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
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**General**

- ☐ Bend
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- ☐ Instructions Incomplete/Unclear
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- ☐ Mislabeled
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- ☐ Outside Dimensions
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

**Item ID:** D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
**Required Date:** 10/31/13 **Req'd Qty:** 1.00 *1* **Customer:**
**Reference:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

RL 14-01-8

8/26/2014

RL 14-01-8

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

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- Work Order Update ☐

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- Small Fab ☐
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- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

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- ☐ Finish
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- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*October-16-13 2:38:43 PM*



**Work Order ID:** 108371

**Parent Item:** D350-604-041 **Start Date:** 10/16/13 **Required Date:** 10/31/13

**Parent Item Name:** Rear Locker Extender **Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:** IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per CHG006/ECN13-616 DDVERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2600-5<br>Camlock Stud | | Purchased | No | | | 155 | Each | 184.0000 | 4 | 4 | | 13·12·04 | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST379 | 100 | 127044 |
| m127044 | 100 | |
| ST396 | 84 | |
| 125602 | 34 | |
| m126400 | 50 | |

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2600-6<br>Camlock Stud | | Purchased | No | | | 155 | Each | 157.0000 | 4 | 4 | 127549 | DAS 33 9-89 | |

DAS 6 9-89

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST380 | 57 | |
| 122973 | 38 | |
| 123150 | 13 | |
| 124704 | 5 | |
| m126400 | 1 | |
| ST396 | 100 | |
| m127044 | 100 | |

DAS 9-89

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2600-LW<br>Camlock Retaining Washer | | Purchased | No | | | 155 | Each | 268.0000 | 4 | 4 | | 13·12·04 | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST396 | 268 | 127549 |
| 121524 | 9 | |
| 122317 | 68 | |
| 123150 | 27 | |
| m126330 | 3 | |
| m126872 | 161 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*October-16-13 2:38:43 PM*

**Work Order ID:** 108371
**Parent Item:** D350-604-041
**Parent Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Required Date:** 10/31/13
**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **D2268** Placard | Manufactured | No | 140 | Each | 41.0000 | 1 | 1 | WM 13:12:04 |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST008 | 41 | | 104271 |
| 100369 | 12 | | |
| 104271 | 7 | | |
| 106096 | 10 | | |
| 106750 | 9 | | |
| 69592 | 2 | | |
| 78908 | 1 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **D2269** Placard | Manufactured | No | 140 | Each | 40.0000 | 1 | 1 | DAS 33 9-89 |

DAS 3 9-89

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST008 | 40 | | |
| 100526 | 6 | | |
| 104393 | 10 | | |
| 106291 | 10 | | 106291 |
| 106916 | 9 | | |
| 88882 | 1 | | |
| 97606 | 4 | | |

DAS 1 9-89

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **D2728-1** Dart Logo Label Small | Manufactured | No | 140 | Each | -1.0000 | 0 | 0 | WM 13:12:04 |
| **D350-604-041P** Rear Locker Extender | Purchased | No | 110 | Each | 4.0000 | 1 | 1 | 108371 LL 13/12/4 |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| CA | 3 | | |
| 103464 | 1 | | |
| 103465 | 1 | | |
| 103913 | 1 | | |
| ST | 1 | | |
| 106461 | 1 | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

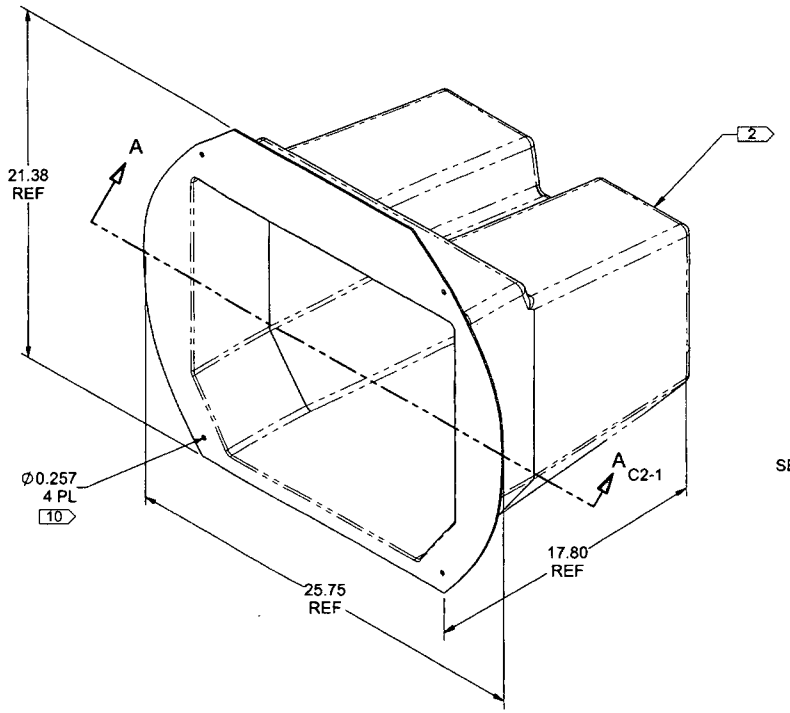
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Mislabeled
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- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

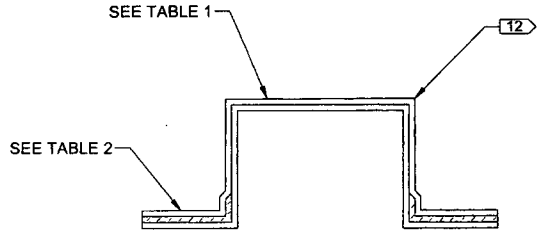
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108371 MCJ
13-10-16




D2273 REAR LOCKER EXTENDER




SECTION A-A
C4-1

UNDER REVIEW
13.07.10 A.T.
NEW G-ELCOAT

RELEASED
2013 -04- 17

## ⚠H TABLE 1

| POSITION | MATERIALS |
|---|---|
| 1 | TOOL SURFACE |
| 2 | GEL COAT |
| 3 | 7725 FIBER GLASS |
| 4 | 3/4 oz CHOPPED STRAND MAT |
| 5 | 7725 FIBER GLASS |
| 6 | 7725 FIBER GLASS |
| 7 | PRIMER |

## ⚠H TABLE 2

| POSITION | MATERIALS |
|---|---|
| 1 | TOOL SURFACE |
| 2 | GEL COAT |
| 3 | 7725 FIBER GLASS |
| 4 | 3/4 oz CHOPPED STRAND MAT |
| 5 | 7725 FIBER GLASS |
| 6 | 7725 FIBER GLASS |
| 7 | 7725 FIBER GLASS |
| 8 | 7725 FIBER GLASS |
| 9 | 7725 FIBER GLASS |
| 10 | PRIMER |

## ⚠H TABLE 3

| MATERIAL USED | DESCRIPTION |
|---|---|
| GEL COAT | 4314-001 DURA FR WHITE GEL COAT |
| FIBER GLASS MAT | OWENS CORNING OR EQUIVALENT 3/4 oz CHOPPED STRAND MAT |
| FIBER GLASS CLOTH | HEXCEL 7725 FIBER GLASS |
| RESIN SYSTEM | PCCR 7524425UPR |
| PRIMER | DEFT MIL-PRF-85582E TYPE 1, CLASS 1 |

⚠H

NOTES:
1) MATERIAL: SEE TABLE 3
2) FINISH: SEE TABLES 1, 2, & 3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 5.5 ~ 7.5 lbs
8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.196
11) CONSTRUCTION: SEE TABLES 1 & 2
12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| H | CHANGE MATERIAL & MANUFACTURING PROCESS | DC | 13.03.15 |
| G | ADD MANUFACTURING OPTION B, ZN B5-1 | DC | 12.08.08 |
| F | PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1 | DC | 12.02.27 |
| E | CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS. | DC | 12.02.02 |
| D | REMOVE EPOCAST, ADD SURFACE FINISH | CP | 02.04.01 |
| C | CLARIFY MATERIAL, LAYUP, AND TOOLING | RF | 02.01.30 |
| B | RE-DRAWN | MM | 96.05.27 |

| | | |
|---|---|---|
| DESIGN | JB | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | DRAWING NO. REV. H |
| CHECKED | | D2273 SHEET 1 OF 1 |
| MFG. APPR. | | TITLE SCALE |
| APPROVED | | 350 REAR LOCKER EXTENDER NTS |
| DE APPR. | | |
| DATE | 13.03.15 | |

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carbon by design
4128 Avenida De La Plata - Oceanside, CA 92056
Phone: 760-643-1300 Fax: 760-643-1333
www.carbonbydesign.com

# Packaging List

**Date:** 12/2/2013
**Packaging List No.** 15914
**Cage Code:** 4DG17
**CBD Work Order No.** 7389
**Customer PO No.:** PO21721

| Billing Address: | Please Deliver To: |
|---|---|
| Dart Aerospace Ltd.<br>1270 Aberdeen Street<br>Hawkesbury, ON K6A 1K7<br>613-632-5200<br>Fed-Ex shipping #15179324-0 | Dart Aerospace Ltd.<br>1270 Aberdeen Street<br>Hawkesbury, ON K6A 1K7<br>Canada |

| Customer Phone | Terms | Rep | Ship Date | Ship Via | Buyer |
|---|---|---|---|---|---|
| 613-632-5200 | Net 30 | JB | 12/2/2013 | FedEx Next Day | Customer |

| Item | Line # | Description | Qty |
|---|---|---|---|
| D2273 | 8 | **Dart Assembly, 350 Rear Locker Extender #D2273 S/N: 15914-1** | 1 |
| D2273 | 9 | **Dart Assembly, 350 Rear Locker Extender #D2273 S/N: 15914-2** | 1 |

| Pricing Good For 30 Days | **Total Items:** _____ | **SHIPPING VALUE** $1,250.00 |
|---|---|---|

## CERTIFICATE OF CONFORMANCE (SHORT FORM CUSTOMERS ONLY)

I certify that on _____, the Carbon by Design LP furnished the supplies or services called for by the Purchase Order Above via Delivery in accordance with all applicable requirements.

I further certify that the supplies or services are of the quality specified and conform in all respects with the contract requirements, including specifications, drawings, preservation, packaging, packing, marking requirements, and physical item identification, and are in the quantity shown in this or on the attached acceptance document.

**Quality:** _____ **Date:** _____

WARNING –This documentl and its attachments may contain technical data, export of which is restricted by the International Traffic in Arms Regulations (ITAR) or the Export Administration Act (EAA) of 1979, as amended. Disclosure to foreign persons without prior U.S. Government approval is prohibited. Violations of these export laws and regulations are subject to severe civil and criminal penalties.

carbon by design

12/2/2013

# CERTIFICATE OF CONFORMANCE

| | | | |
|---|---|---|---|
| **PO: No.:** 21721 | **DESC:** 350 Rear Locker Extender | **Insp:** JB | **Packing #:** 15914 |
| **Customer:** Dart Aerospace Ltd | **Drawing:** DWG D2273 Rev H | **Qty:** 2 | **Serials:** 15914-1/15914-2 |

**Work Requirements:**

| | |
|---|---|
| Statement of Work: | SOW on file |
| Internal Process Doc.: | 2206-253 |
| Inspection Document: | 2206-253 |
| Manufacturing Process: | Infusion |
| Security Requirement: | Confidential |

| | |
|---|---|
| **Approved Non-Conformances:** NO | **Pending:** NO |
| **DISPOSITION:** To Customer, Ship | **SHIP METHOD:** FedEx Next Day |

**Certification Statement:**
Carbon by Design LP certifies the items listed above conform to all of the applicable work and quality standard required in the purchase order listed above and any additional work requirements referenced.

All in process quality standards have been met according to customer requirements and Carbon by Design internal quality and finish requirements. All materials Certification are available for inspection and will remain on file at Carbon by Design for a period of no less than ten years.

**Finished Materials/Process Specifications:**
Per Drawing Requirements

**Additional Quality Clauses:**
Per PO Requirements, 100% Inspection

**Active Quality Systems:**
ISO9001:2008

**Inspector's Name:** Joel Barrera

**Signature:** 

**Title:** Quality Manager **Date:** 12/2/13

# Work Order ID 108371

*108371*



*October-16-13 2:38:43 PM*

**Item ID:** D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Rear Locker Extender

**Start Date:** 10/16/13 **Start Qty:** 1.00 *1*

**Required Date:** 10/31/13 **Req'd Qty:** 1.00 *1*

**Cust Item ID:**

**Customer:**

**Reference:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** MLJ **Date:** 13-10-16 **Tooling:** **Date:**

**QC:** **Date:** **SPC (Y/N):** **Date:**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2273 | H | | | | | | | | |
| D350-604-041 | D | 0.00 | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | **Memo** | | | | | | | | |
| Document Control | Photocopy bluefile and create labels per PPP D350-604-041 CHG006 | | | | | | | | |

JB 13.10.16

MLJ 14-01-07

see attachment

005

PART NUMBER: D2273
REV LEVEL: -H
UN-CLASS
12/2/2013
Product : 350 Rear Locker Extender
Customer: Dart
SN # 15914-2
PO # 21721
WO # 7389
Weight 6.34 Lbs
D2273

# Change Record



Part Number: D350-604-041

Description: REAR LOCKER EXTENDER

| CHG # | DATE | BY | RELEVANT DOCUMENTS | ECN # |
|---|---|---|---|---|
| 001 | 99.08.12 | CS/KE | D350-604 REV B, D2268, D2269, D2273 REV B | |
| | | | | |
| 002 | 09.07.15 | KJ | DSI 9470 REV A | 09-626 |
| | | | | |
| 003 | 12.02.06 | KJ | D2273 REV E | 12-521 |
| | 12.02.22 | KJ | D350-604 REV C, ICA-D350-604 REV 0 | 12-531 |
| | | | | |
| 004 | 12.03.29 | KJ | D350-604-041 REV B, D2273 REV F, ICA-D350-604 REV 1 | 12-540 |
| | | | | |
| 005 | 13.04.18 | KJ | D350-604 REV D, D2273 REV H, ICA-D350-604 REV 2 | 13-551 |
| | | | | |
| 006 | 13.09.11 | KJ | D2273 REV I, MDL-D350-604 REV E | 13-616 |
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